

Date: Thursday, 6/29/2006 8:28:12 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT BRACKET			
Job Number	: 27765						
Estimate Number	: 10260						
P.O. Number	: N/A			Part Number	: D23623		
This Issue	: 6/29/2006	S.O. No.	: N/A	Drawing Number	: D2362 REV E1		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: N/A		Type	: MACHINED PARTS			
Previous Run	: 27309			Drawing Revision	: E1		
Written By	: <i>Seiji</i> <i>COMMENT Below</i>			Material	: N/A		
Checked & Approved By	: <i>Seiji 06/06/09</i>			Due Date	: 7/30/2006		
Comment	: Est: G 00008.18 Added inspection level 8 EC			Qty:	10	Um: Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2265	Step Support Casting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	<i>B25401</i>

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

JL 06/07/27 x 10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

JL 06/07/27 x 10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 06/07/27 x 10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

m.F. 06/07/28 - ⑩

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1)as per Dart QSI 005 4.3

a.m 06-08-09 ⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: Date: 06/09/10

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 6/29/2006 8:28:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 27765

Part Number: D23623

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Job 06/08/03



Comment: INSPECT POWDER COAT

8.0 D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number Description Batch

1 D2397-1 Rubber

B25469 (1mx) B 27768 (9mx)

9.0 D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number Description Batch

1 D2397-3 Rubber

B25470 (1mx) B 27769 (9mx) MF 06/08/03

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch M 16/194

MF 06/08/03 ⑩

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *ST173*

AP 06/08/08 ⑩

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

⑩ 06/08/09

Job Completion



W 06/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27765
Description: Step Support Bracket	Part Number:	D2362-3
Inspection Dwg: D2362 Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	JL	Audited by:	me	Prototype Approval:	N/A
Date:	06/07/27	Date:	06/07/27	Date:	N/A

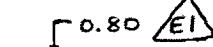
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	

EI

03.10.07

TOLERANCE CHANGE #REF

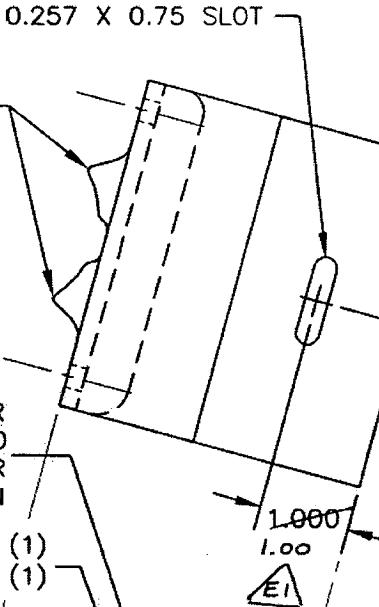
VIEW A-A



REMOVE TIPS
FROM CASTING
MAX 0.080

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

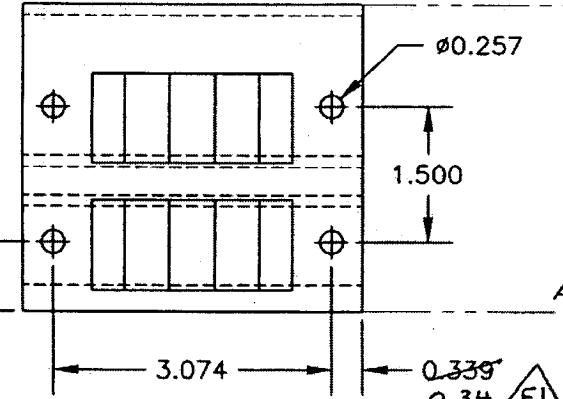
D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)



RELEASED
98.12.14 KE

DART
COPYRIGHT

DESIGN BW	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED <i>W</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 1 OF 3 SCALE 1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5



D2362-3

DESIGN OK, BUT CHECK WITH
THE MANUFACTURE
BEFORE MANUFACTURE
OK 04/11/99

03.12 CP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPIES
SUBJECT TO AMENDMENT

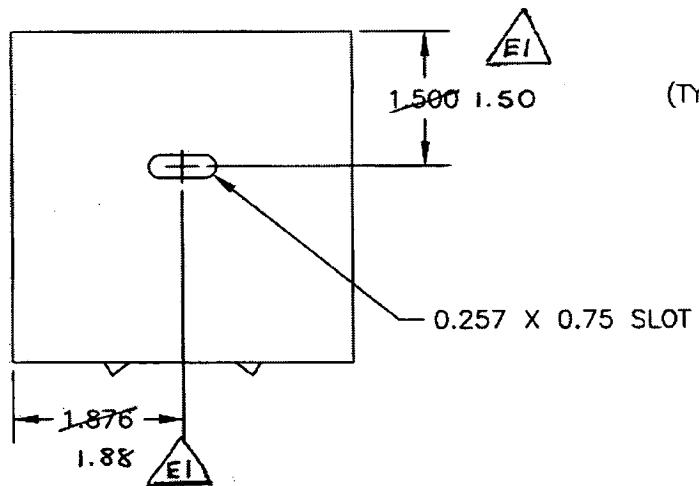
NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

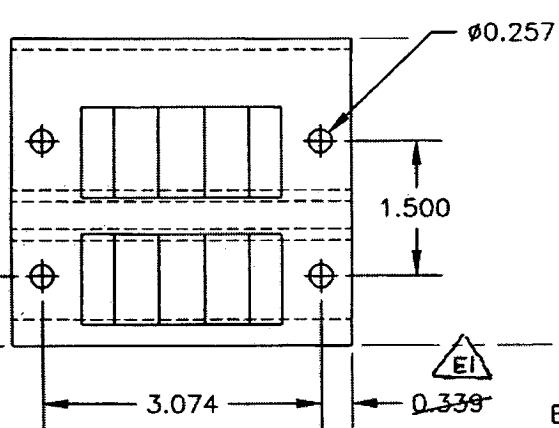
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

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DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD
CHECKED <i>KE</i>	APPROVED <i>JF</i>	HAWKESBURY, ONTARIO, CANADA
DATE 98.12.04	DRAWING NO. D2362	REV. E
TITLE STEP SUPPORT BRACKET	SHEET 2 OF 3	SCALE 1:2

RELEASED
12-14-98
UNDER REVIEW
98.03.05 CP

Design note, by *CP*, check w/
JTB before manufacture
OK *CP* 12-14-98

D2362-041 (SHOWN)

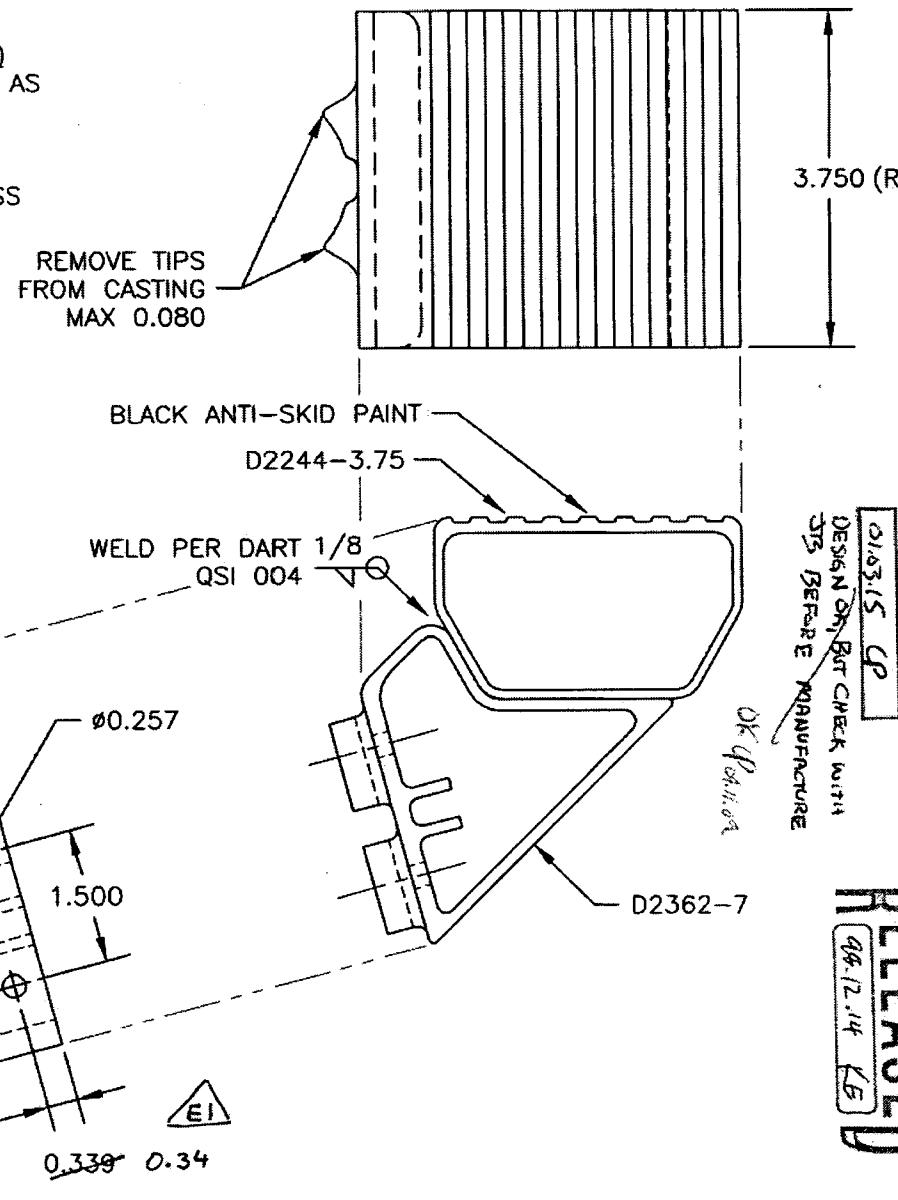
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECDED <i>RE</i>	APPROVED <i>M</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 3 OF 3 SCALE 1:2

UNDER REVIEW
RELEASED

01.03.15 CP

DESIGN OK, BUT CHECK WITH
JTB BEFORE MANUFACTURE

48-12-14
LG

